

Work Order ID 86204

86204

Page 1

June-22-12 3:04:18 PM

Item ID: D4072-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Airframe Hinge

Start Date: 22/06/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4072

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT 1.250" LONG

CT 12-08-01 x 16

105

0.00

105

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg on Folio FA938

Dwg Rev: AA

Folio Rev: AA

12/08/14

12-08-15 16

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

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SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

12/08/16

12-08-15

FK- 12/08/18

16

16

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Start Time: 12:40
Temp: 32.0 °F
Finish Time: 1:10

160

Powdercoat

Memo

Powder Coating

170 QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180	Identify as per dwg & Stock Location: <u>071</u>	0.00
-----	--	------

180

Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MJS 12/08/23

U 1208, 29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-22-12 3:04:21 PM

Page 1

Work Order ID: 86204

86204

Parent Item: D4072-1

D4072-1

Parent Item Name: Airframe Hinge

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 16.00

Required Qty: 16.00

Comments:

Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD
REV:B DRAWING REV. CHANGE AS PER ECN 11-598
VERIFIED BY:

IPP
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.50 0		Purchased	No			100	f	13.7060	0.104	1.751579			

M6061T6B1 000X02 500

6061-T6 Bar 1.00 x 2.50

**

RT 12-08-01

Location

Loc Qty

Loc Code

MAT003

13.706

114993

13.706

x 1.751579

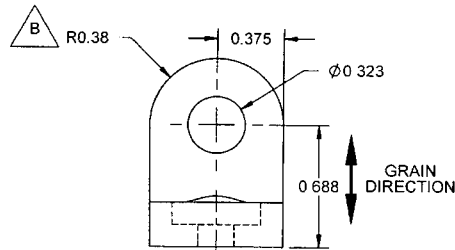
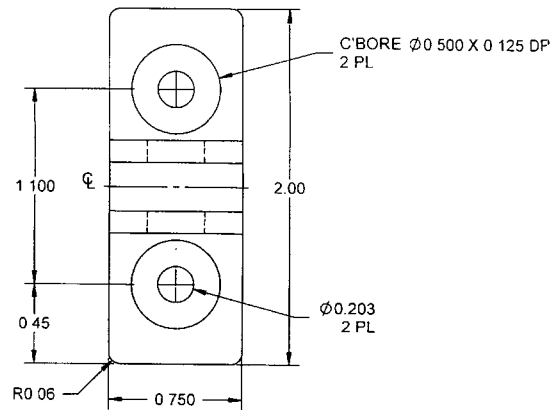
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

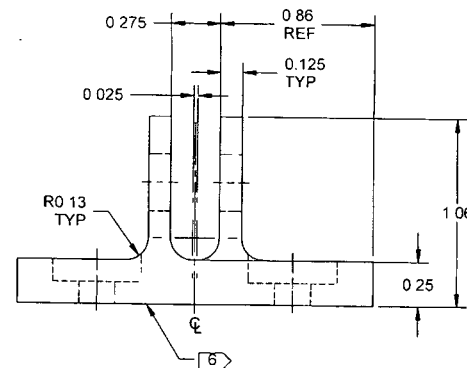
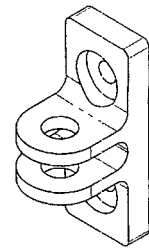
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86204 MJS
12/06/22



D4072-1 AIRFRAME HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-06-30

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.02		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D4072** REV. B
TITLE **AIRFRAME HINGE** SCALE NTS
SHEET 1 OF 3

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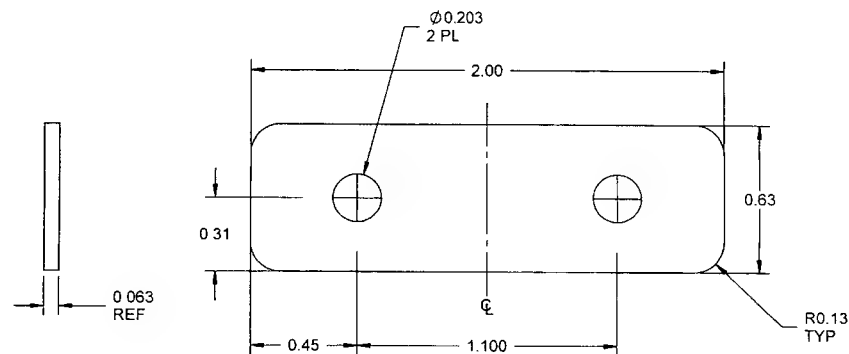
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4072-3 AIRFRAME HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3 5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D4072	SHEET 2 OF 3
MFG APPR.	RF	TITLE	SCALE
APPROVED	RF	AIRFRAME HINGE	NTS
DE APPR.	RF	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	10.11.02		

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2011-06-30

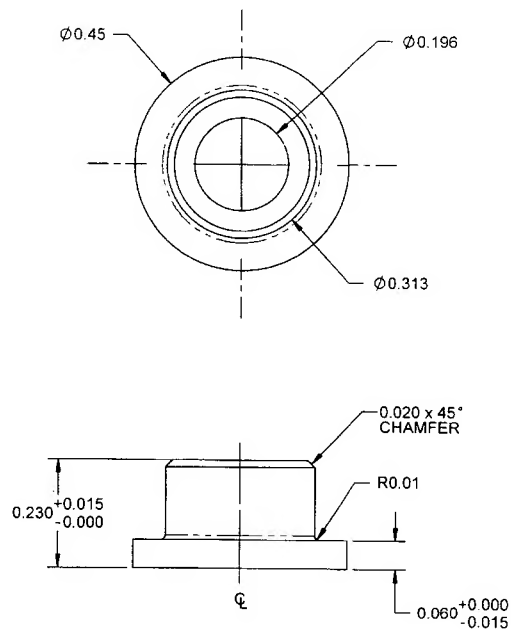
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

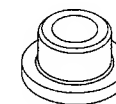
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4072-5 BUSHING



86204

RELEASED
2011-06-30

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4072	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AIRFRAME HINGE	NTS
DATE	10.11.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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DART AEROSPACE LTD		Work Order:	816204
Description: Airframe Hinge		Part Number:	D4072-1
Inspection Dwg: D4072 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	.500 x .125	✓		vern	25 - 4
2.00	+/-0.030	2.000	✓		"	
Ø0.203	+0.005/-0.001	.203	✓		"	
0.750	+/-0.010	.749	✓		"	
R0.06	+/-0.030	.060	✓		sub gauge	
0.45	+/-0.030	.446	✓		vern	25 - 4
1.100	+/-0.010	1.101	✓		"	
R0.38	+/-0.030	.368	✓		"	
0.375	+/-0.010	.371	✓		"	
0.688	+/-0.010	.688	✓		"	
0.275	+/-0.010	.273	✓		"	
R0.13	+/-0.030	.130	✓		sub gauge	
0.25	+/-0.030	.251	✓		vern	
1.06	+/-0.030	1.061	✓		"	
0.125	+/-0.010	.126	✓		"	
0.86	+/-0.030	.864	✓		"	
Ø0.323	+0.005/-0.001	.323	✓		"	

Measured by: ZT ^{DAS} 13	Audited by: F.K.	Preliminary Approval:
Date: 12-08-15	Date: 12/08/15	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	
B	11.10.13	Dimension 0.25 removed	KJ	

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